

OLD Style! Spt-9

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 3:04:55 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 28199	
Estimate Number : 11040	
P.O. Number : N/A	Part Number : D28042
This Issue : 15/08/2006 S.O. No. : N/A	Drawing Number : D2804 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL/MED FAB	Drawing Revision : B
Previous Run : 27685	Material : N/A
Written By : _____	Due Date : 09/08/2006 Qty: 8 Um: Each
Checked & Approved By : _____	
Comment : Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s)
6061-T6 Bar .50" x 12.0"
Material: 6061-T6 bar 12.00" x 0.50" Batch: M101263

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Template DT8534
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

SAP 06.08.16 (8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per folio FA103

JL 06/08/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06/08/21

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SJ 06.08.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/21	3	D2804-2 was placed crossed on the millling, And At the top hole location was not machined due to the hole being too close to the edge		Scrap & destroy, replace. ensure part is placed properly in machine.	J.L. 06/08/21	 06-08-22		 06-08-22

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 3:04:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 28199

Part Number: D28042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

SA 06.08.22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-29 (8)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST156

DL 06/08/29 (8)
DL 06/08/30 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DL 06/08/31 (8)

Job Completion



DL 06/08/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

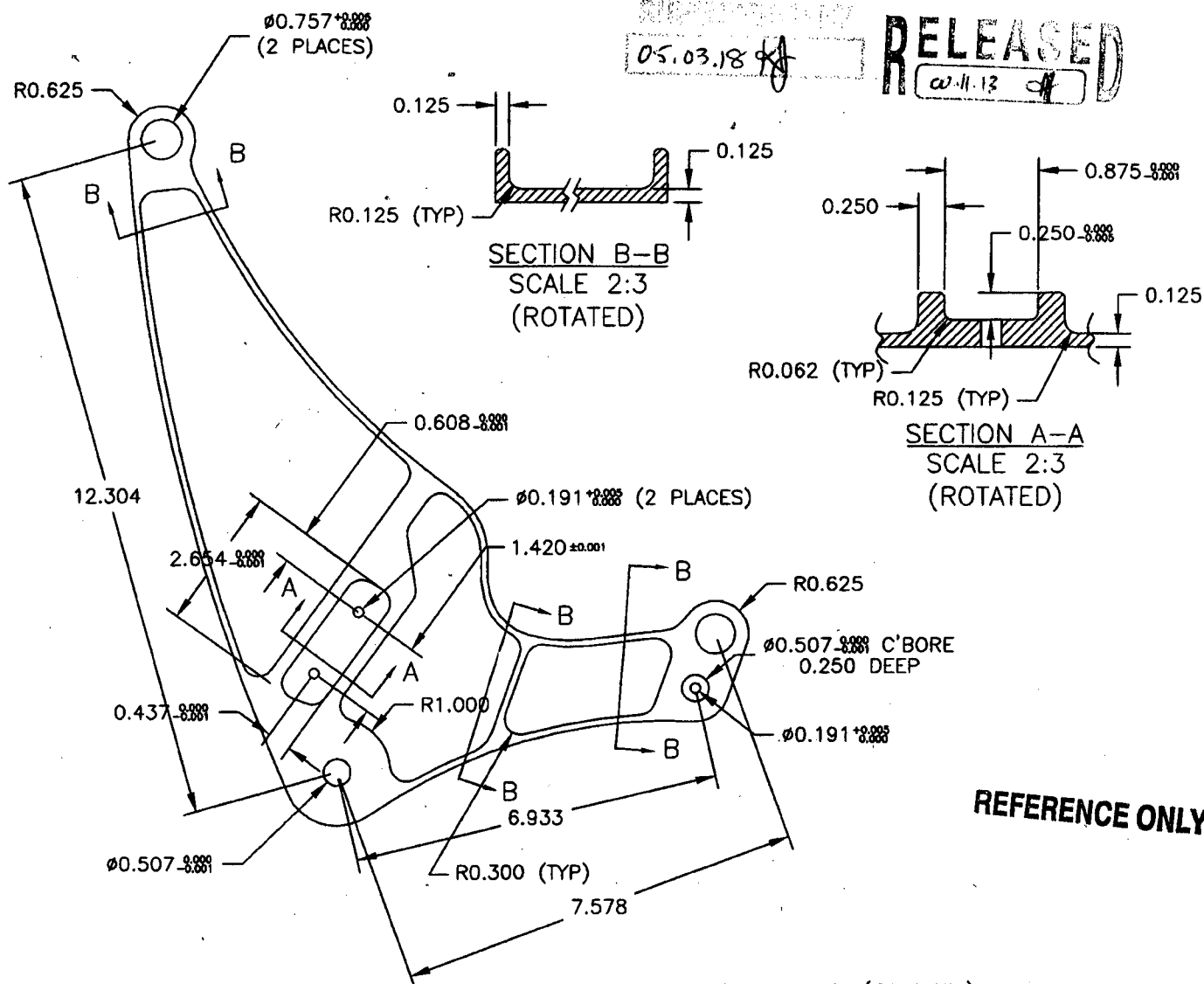
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 <i>[Signature]</i>	

05.03.18 *[Signature]*

RELEASED
01.11.12 *[Signature]*



REFERENCE ONLY

D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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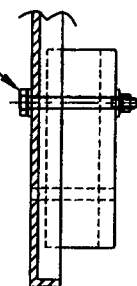
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

RELEASED
00.11.13

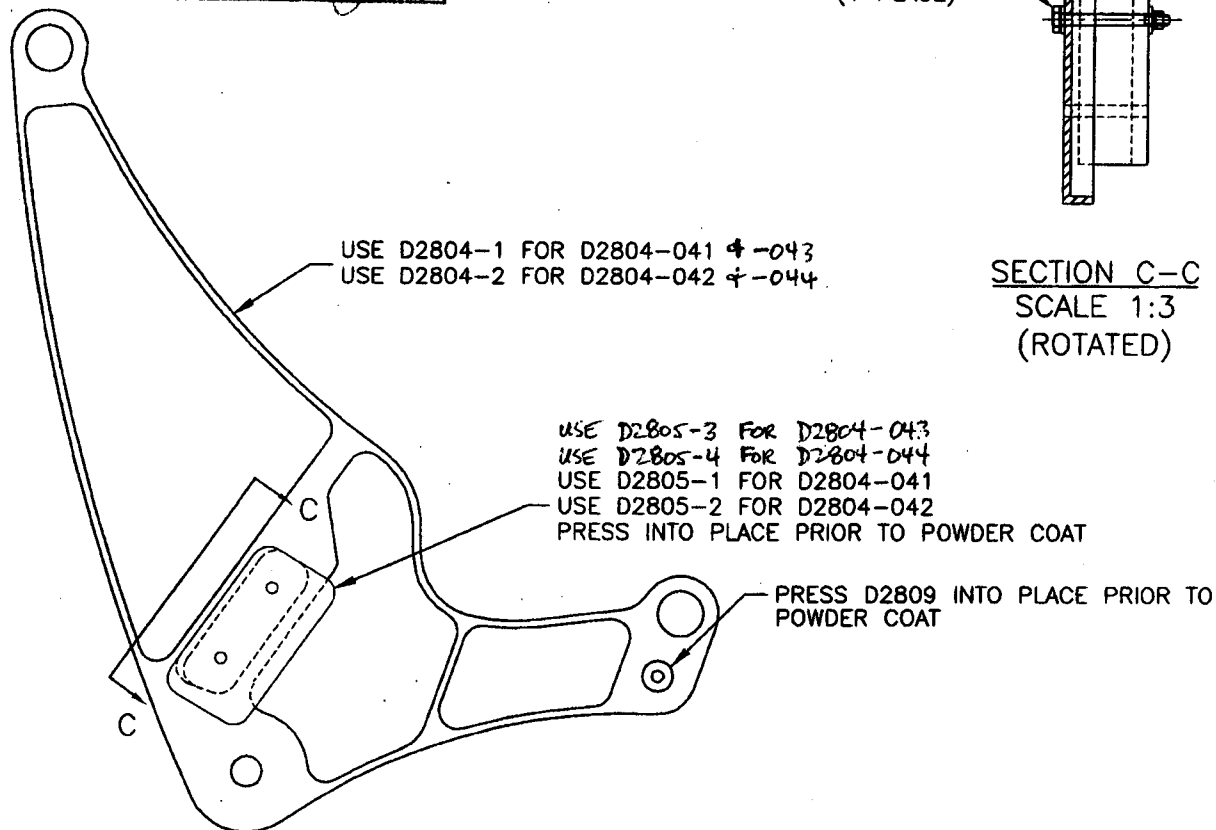
SUPERCEDED BY

05.03.18

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order:	
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.128	✓			
R0.125	+/-0.010	.125	✓			
0.250	+/-0.010	.250	✓			
0.250	+0.000/-0.005	.248	✓			
0.875	+0.000/-0.001	.875	✓			
R0.062	+/-0.010	.062	✓			
Ø0.757	+0.005/-0.000	.759	✓			
R0.625	+/-0.010	.625	✓			
12.304	+/-0.005	12.304	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
0.437	+0.000/-0.001	.437	✓			
0.608	+0.000/-0.001	—				cannot measured
Ø0.191	+0.005/-0.000	.193	✓			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	.250	✓			
6.933	+/-0.005	6.933	✓			
7.578	+/-0.005	7.578				

Measured by:	J.L	Audited by:	gml	Prototype Approval:	N/A
Date:	06/08/21	Date:	06/08/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	